

Work Order ID 59626

Page 1

Wednesday, June 09, 2010 8:42:15 AM

Item ID: D3791-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearplate

Start Date: 6/9/2010 Start Qty: 12.00

Cust Item ID:

Required Date: 6/24/2010 Req'd Qty: 12.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date: 10-6-09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3791

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3791

Dwg Rev: A

Prog Rev: A

304 .063

2-Deburr if necessary

B10-6-22



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-6-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S 10/06/23

(12)

130

NC BRAKE

0.00



Brake NC

Memo

0.00

Brake NC

1-Deburr if necessary

2-Form on Brake as per Dwg D3791 using Jigs

SP 10/06/23

(12)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Ensure joggle as per dwg D3429

S 10/06/23

(12)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

[illegible]

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Setup Start

Stop

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete each task.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress along the way. It is important to stay flexible and make adjustments as needed.

5. The final step is to evaluate the results of the project. This involves assessing whether the objectives were met and identifying any lessons learned for future projects.

Cust Item ID:[illegible]

Customer:

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
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**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

0.00



Large Fab

0.00

Large Fab

Memo

1-Weld hardcoat as per dwg D3791 QSI004

Hardcoat 2059b Batch: M 114642

160

[illegible]

QC10- Inspect visual per QSI004- ground welds

0.00

QC

Memo

0.00

Quality Control

170



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Page 4

Item ID: D3791-1

Accept

Revision ID:

Item Name: Wearplate

Start Date: 6/9/2010 Start Qty: 12.00

Required Date: 6/24/2010 Req'd Qty: 12.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

M112588

0.00

Powder Coating

Memo

START TIME: 11:45
OVEN TEMPERATURE: 320°
FINISH TIME: 12:15

12 BR 10-6-28

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

M 10 28 (12)

200

Identify as per dwg & Stock Location FP-17

0.00



Packaging

Memo

0.00

Packaging

12 9

W/O:		WORK ORDER CHANGES					
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Work Order ID 59626

Wednesday, June 09, 2010 8:42:15 AM



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Item ID: D3791-1

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 6/9/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 6/24/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
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Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/29

10/06/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, June 09, 2010 8:42:19 AM

Page 1

Work Order ID: 59626



Parent Item: D3791-1



Parent Item Name: Wearplate

Start Date: 6/9/2010

Required Date: 6/24/2010

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-22 revA as per dwg ECN1191 DD verified by:EC

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	128.0000	0.2917	3.684632			



304/316 Sheet .063



B10-6-22

Location

Loc Qty

Loc Code

MAT	128	
111323	0	
114799	128	

114799

12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

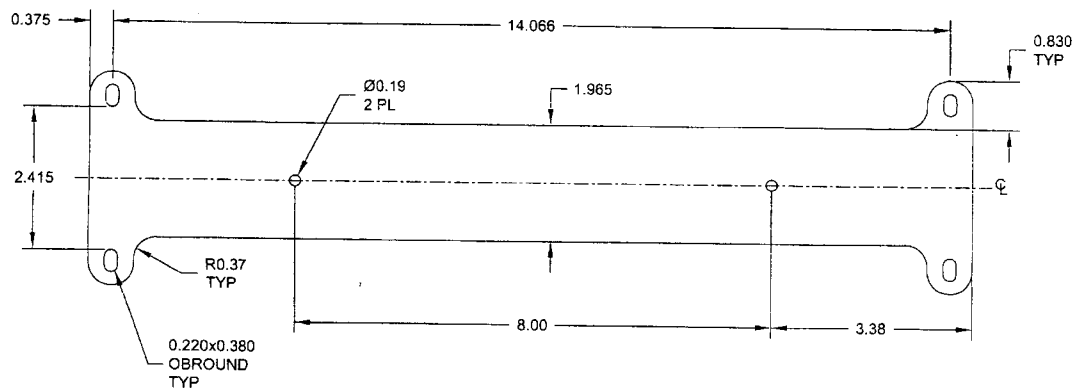
W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

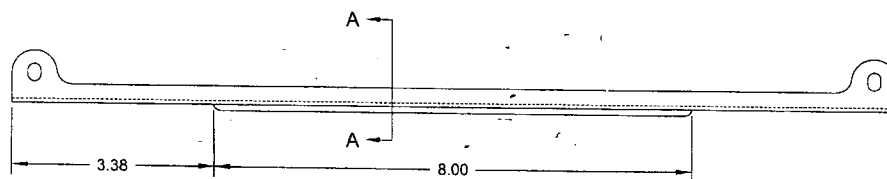
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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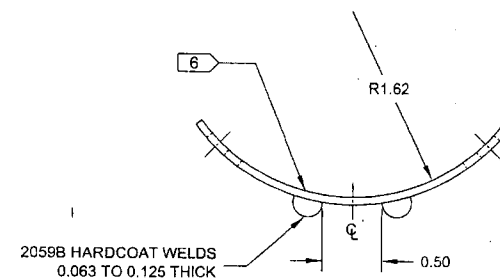
NOTE: Date & initial all entries



D3791-1F FLAT PATTERN



D3791-1 WEARPLATE
 (MAKE FROM D3791-1F)



SECTION A-A
 SCALE 2X

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 59626
 BJO-6-09

RELEASED
 08-05-13

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
 (REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3791-1" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.70 LBS
- 8) WELD PER DART QSI 004

REV.	NEW ISSUE	DESCRIPTION	PH	08.05.13
DESIGN	PH		BY	DATE
DRAWN	PH			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.05.13			

DART AEROSPACE USA, INC
 PORT HADLOCK, WA
 DRAWING NO. D3791
 TITLE WEARPLATE
 SCALE NTS
 REV. A
 SHEET 1 OF 1
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